

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003700**Date Inspected:** 18-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Ji / Li Yang / Sun Wei			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	skin plates and stiffeners / deck panels		

Summary of Items Observed:**Tower Shop – Bay 1**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed ZPMC personnel performing the following: air arcing; restraining of SSD1- skin B using screw jacks; SAW of stiffener butt welds. Approximately 80 workers were present in this shop including ZPMC CWI Liu Huajie and ABF QC Xiao Jun Peng.

Tower Shop – Bay 2

QA Inspector randomly observed ZPMC personnel performing the following: grinding of stiffener to skin plate welds; drilling of approximately 50mm holes in stiffeners ESD1- D1, D2, D3, and D4; FCAW and SAW of stiffener butt welds; grinding of stiffener to skin tacks on ESD1- skin B; air arcing and grinding of stiffener butt welds. ZPMC CWI Li Yand and ABF QC Xing Xiao Guang were present as well as approximately 45 ZPMC workers.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed ZPMC personnel performing the following: grinding on the following deck panels: DP270-001 and DP619-001; obtaining UT readings on DP559-001 and DP584-001. QA Inspector performed initial VT on the closed rib to deck plate welds on DP018-002 simultaneously with ZPMC CWI Sun Wei and ABF QC Wang Zhong Yuan. All three parties performing the VT concurred on repairs to be made. Sixteen ZPMC workers and sixteen deck panels were present in this bay.

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Summary of Conversations:

As noted above in Items Observed section.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer